



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

647.7913
Job Sheet 169394



Part No: 647.7913

Job Qty: 10 ea

Part Name: Doubler



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 12/8/17

Job Tracking No:

Due Date: 1/12/18

Created By: Mario Poulin

Type: Stock

Description:

Note: DWG REV N/C SHEET 5 IPP REV:A 12.10.03 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	1/11/18	1/11/18	0.00	0.00	Start Up Waterjet		DL 17/12/27
110	Waterjet	10 pcs	1/11/18	1/11/18	0.00	0.59	Waterjet1		DL 17/12/27
120	QC	10 pcs	1/11/18	1/11/18	0.00	0.00	QC2 Waterjet-1		DL 17/12/27
130	QC	10 pcs	1/11/18	1/11/18	0.00	0.00	QC8-1		38
140	Outsource	10 pcs	1/11/18	1/11/18	0.00	0.00	Outsource4		38 JAN 23 2018
150	Packaging	10 pcs	1/11/18	1/11/18	0.00	0.00	Packaging2		38 JAN 23 2018
160	QC	10 pcs	1/11/18	1/11/18	0.00	0.00	QC5		38
170	SprayPaint	10 pcs	1/12/18	1/12/18	0.00	0.23	Spray Paint		9-88 JAN 24 2018
180	QC	10 pcs	1/12/18	1/12/18	0.00	0.00	QC14		
190	Packaging	10 pcs	1/12/18	1/12/18	0.00	0.00	Packaging3-1		66-115 A7 18/01/24 A7 18/01/24
200	QC21-SA	10 Ea	1/12/18	1/12/18	0.00	0.00	QC21		

Part Op 110 - 1-Cut as per Dwg

Descriptions: 140 - ISSUE P/O:

170 - PRIME IAW MIL-P-23377J TYPE1 CLASS N AS PER DWG. (SEE NOTE 2)

190 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

DAS
21
9-88

JAN 26 2018

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M2024T3S.063	1	261	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

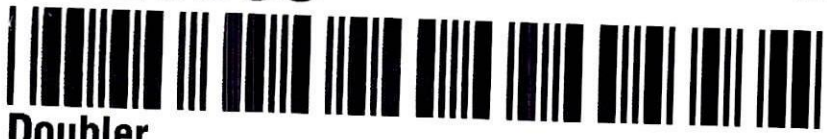
Date: _____

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Environment
Design
Doc/Data
Equip/Tooling
Handling/Pre
Material
Internal Transport
Tribal Knowledge

LOA
Substation
Past Expiry Date
Misidentified
Product Improvement
Process Improvement
Manufacturing Process
Past Due

DART
AEROSPACE
S026968



Doubler

PART NO: 647.7913
Original Serial #: S026968
Revision:
Operation: Outsource
Change No:

Mfg Date: 12/27/17
Job No: 169394

Wave/Twist in Tube
Marks/Chatter

OTHER: _____

Temp
Set-u
BOM
Brok
Inspe
Cont
Coui
Cut

DART
AEROSPACE
S026968



Doubler

PART NO: 647.7913
Revision:
Operation: Start up Operation
Change No:

Mfg Date: 12/27/17
Job No: 169394

Drill Holes

Misalignment/curvature

Turning Sequence

Positioned Wrong
Outside Dimensions
Over/Under tolerance
Part Incorrect
Part Lost/Missing
Part Moved
Drawing
Finish
Miscellaneous

/ QA Coordinator
Approval

and / Supervisor
Approval Verification

Completed By

SIGAZ Approval

Engineering
Quality
Other

AGAINST DEPARTMENT/PROCESS

DART
AEROSPACE



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 914460

Date: 22-Jan-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chantal Lavoie
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		OUR TRUCK	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
10 ea	Part: 647.4115 Shim Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 22300		Rev: N/C PO: PO038727 Line: 10
10 ea	Part: 647.7913 Doubler Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 22301		Rev: A PO: PO038727 Line: 11
12 ea	Part: 646.3719 Doubler Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 22305		Rev: A PO: PO038727 Line: 15
10 ea	Part: 646.3811 Radius Block Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 22306		Rev: A PO: PO038727 Line: 16
10 ea	Part: 647.4114 Shim Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 22300		Rev: N/C PO: PO038727 Line: 10
Made in Canada.			



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PURCHASE ORDER

PO038727

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
8	168031	647.3916	Splice Plate Issue P/O _____ATG, black anodize and prime as per dwg 647.1612 Rev. A							
			Deflector Issue P/O to ATG :	Firmed	1/30/17	2 pcs	0 pcs	2 pcs	\$18.80/pcs	\$37.60
9	168033	647.4114	Hard Anodize Color Black, Prime as per Dwg 647.3900 Rev. C							
			Shim Issue P/O _____ATG, black anodize and prime as per dwg 647.4114 Rev. N/C	Firmed	1/30/17	10 pcs	0 pcs	10 pcs	\$6.95/pcs	\$69.50
10	168034	647.4115	Shim Issue P/O _____ATG, black anodize and prime as per dwg 647.4115 Rev. N/C	Firmed	1/30/17	10 pcs	0 pcs	10 pcs	\$6.95/pcs	\$69.50
11	169394	647.7913	Doubler Issue P/O _____ATG, black anodize and prime as per dwg 647.7913 Rev. A	Firmed	1/30/17	10 pcs	0 pcs	10 pcs	\$8.10/pcs	\$81.00
12	168215	646.2910	Deflector Issue P/O to ATG : Hard Anodize, Color Black / Prime As per Dwg 646.2900 Rev. N/C	Firmed	1/30/17	2 pcs	0 pcs	2 pcs	\$48.70/pcs	\$97.40
13	168247	646.3717	Doubler Issue P/O _____ATG, black anodize and prime as per dwg 646.3717 Rev. A	Firmed	1/30/17	20 pcs	0 pcs	20 pcs	\$6.95/pcs	\$139.00
14	168248	646.3718	Custom Washer Issue P/O _____ATG, black anodize and prime as per dwg 646.3718 Rev. A	Firmed	1/30/17	40 pcs	0 pcs	40 pcs	\$4.65/pcs	\$186.00
15	168249	646.3719	Doubler Issue P/O _____ATG, black anodize and prime as per dwg 646.3719 Rev. A	Firmed	1/30/17	12 pcs	0 pcs	12 pcs	\$6.95/pcs	\$83.40
16	168251	646.3811	Radius Block Issue P/O _____ATG, black anodize and prime as per dwg 646.3811 Rev. A	Firmed	1/30/17	10 pcs	0 pcs	10 pcs	\$7.25/pcs	\$72.50
17	168228	646.3312	Center Plate Issue P/O to ATG :	Firmed	1/30/17	8 pcs	0 pcs	8 pcs	\$12.75/pcs	\$102.00